

## **CARGO BASKET LID FABRICATION - COMMON**

WO 2014-20

AS350 LONG STAINLESS

### **General**

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90612, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95912, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82812, Revision 0 – Standard Basket

#### **Options**

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

## CARGO BASKET LID FABRICATION

Complete  
(initial or SCA #)

Work Order: 2014-20

Date Open: 30 Feb 15

06 Mar 14 *OK*

### 1. Rim Assembly – Basket Lid

*AD-05*

- a. Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
  - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

### 2. Weld Rim Assembly

*AD-05*

- a. Record welding rod PO on attached material list.

### 3. Inspection

*OK*

- a. Rim for complete welds

### 4. Frame assembly – Lid

*AD-05*

- a. General
  - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit  $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

### 5. Frame assembly – Lid with optional walkway modification

*AD-05*

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut  $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

### 6. Weld frame assembly.

*AD-05*

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

### 7. Inspection

*AD-05*

- a. Frame assembly for complete welds.

## CARGO BASKET LID FABRICATION

Complete  
(initial or SCA #)

#206

### 8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

### 9. Weld mesh to frame assembly per drawing.

AD-05

- General welding requirements for all lids:
  - Every intersection on all edges.
  - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
  - $\frac{3}{4}$ " for lids under 76"
  - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

### 10. Weld lid components.

AD-05

- Handle brackets, locate in accordance with drawing.
  - Standard location:  $\frac{1}{4}$ " outside of last cross member on both ends.
  - Record handle bracket WO and welding rod PO on attached material list.
- ✓ Lid prop bushing(s).
  - one or two in accordance with drawing.
  - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
  - Locate on cross member to set bracket in centre bay of lid.
  - Record placard bracket WO and welding rod PO on attached material list.

### 11. Clean up

M/06

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- Drill for lid bumpers using  $\frac{1}{4}$ " (#3) centre drill.
  - 3 places for lids under 76"
  - 4 places for lids over 76"
- Remove surface rust with scotch-brite pad.

### 12. Final Inspection

To be completed by a different person than the previous steps.

AD01

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

## CARGO BASKET LID FABRICATION

Complete  
(initial or SCA #)

N/A

### 13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.



Work Order: \_\_\_\_\_

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Lid Fabrication

1 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			<b>78412-01</b>	<b>Lid Assembly</b>		
<b>Step 1</b>				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	304 S/S <del>367502</del> 11101
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	304 S/S <del>367502</del> 11101
<b>Step 2</b>				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	<del>ER70S-2 TIG Rod</del>	ER 308L PO# 14005
<b>Step 3</b>				<i>Inspection - Rim</i>	None	
<b>Step 4</b>				<i>Frame Assembly</i>		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	304 S/S 11101
<b>Step 5</b>		70405		<i>Option: Frame Assembly - with walkway</i>		
	. 8		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	304 S/S 11101
<b>Step 6</b>				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	<del>ER70S-2 TIG Rod</del>	ER 308L PO# 14005
<b>Step 7</b>				<i>Inspection - Frame Assembly</i>	None	
<b>Step 8</b>				<i>Mesh Assembly</i>		
	. 1		--	Mesh (lid - 92.5" x 22")	3/4-16F Expanded Mild Steel sheet	S/S <del>1102</del> 11032
<b>Step 9</b>				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	<del>ER70S-6 MIG Wire</del>	ER 308L PO# 14005

Work Order: \_\_\_\_\_

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Lid Fabrication

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 10</b>				<i>Weld Lid Components</i>		
	1	84262	84262-01	Upper Handle Bracket Assembly		
	4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	2		36275-02	Support	304 Stainless, 5/16" Rod	
	A/R		--	Welding Rod	ER308L TIG Rod	
	2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	PO# 8096
	A/R		--	Welding Rod	ER308L TIG Rod	PO# 14005
	1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	
	A/R		--	Welding Rod	ER70S-2 TIG Rod	
<b>Step 11</b>				<i>Clean Up</i>		
<b>Step 12</b>				<i>Inspection - Final Assembly</i>		
<b>Step 13</b>				<i>Powder Coating</i>		

## CARGO BASKET HOOP FABRICATION - 76421

### General

These instructions apply to cargo basket hoop 76421-01 and derivatives that use it as stock. Refer to the following drawings, at the current revision, for dimensions and details:

76421, Revision 0 – Hoop

#### Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2014-20

Complete  
(initial or SCA #)

Date Open: 06 MAR 2014

#### 1. Hoop Fabrication

ADOL

- a. Cut  $\frac{1}{2}$ " x 0.035 material to 48.0"?, one end square, one end @ 16 degrees.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??
  - ii. Lower bend stop: ??
- f. Slide stock tube through bending die up to upper stop, angled end of tube, long side away. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die.
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle and height using hoop jig. Adjust stops if required.
- j. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??
  - ii. Lower bend stop: 12mm
- k. Slide stock tube through bending die up to upper stop, square end of tube. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- l. Slide shim all the way forward on bender to secure tube in die.
- m. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- n. Check tube bend for square and height using hoop jig or carpenters square. Adjust stops if required.
- o. Check for:
  - i. hoop height: 17  $\frac{1}{8}$ " (Outside to outside)
  - ii. hoop width at top: 21" (inside to inside)
  - iii. adjust upper stop for height if required
  - iv. adjust stock length for width if required
  - v. twist – due to pulling bending arm up or down through bend



• CARGO BASKET HOOP FABRICATION - 76421

- p. Drill #30 vent holes in bottom centre of hoop in fore/aft direction. De-burr with scotch-brite disc on die-grinder.
- q. Inspect hoops for conformity to drawing.
- r. Tag complete and inspected hoop(s) and place into stock.



## CARGO BASKET HOOP FABRICATION - 76423

### General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

### Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2014-20

Date Open: 06 MAR 2014

Complete  
(initial or SCA #)

#### 1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 22.0", square ends. APG
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??"
  - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 17 1/8" (Outside to outside)
  - ii. adjust upper stop for height if required

#### 2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01)

- a. Start with ½" half hoop from step 1. APG
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.

AD 06

## 3. ½ Hoop Fabrication – 1" hoop

- a. Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??
  - ii. Lower bend stop: ??
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle using hoop jig. Adjust stops if required.
- j. Check for:
  - i. hoop height from jig
  - ii. adjust upper stop for height if required
  - iii. length to allow 60 degree cut.
- k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- l. De-burr cut end using a sanding disc on a die-grinder or disc sander.

## 4. ½ Hoop Machining – 1" hoop

AD 06

- a. Start with 1" ½ hoop as stock.
- b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
- c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Set tube in vise with 60 degree end on right.
- f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- h. Tag in process hoop(s) and place into stock.

## 5. Joint Preparation

AD 06

- a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

## 6. Welding – Lugs

AD-05

- a. Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- b. TIG weld all around both sides of lugs. 2 places.
- c. Record lug and welding rod PO/WO on attached material list.

7. Welding – Handle Bushings – 84262-01

- a. Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

8. Welding – Hoop Assembly

AD-05

- a. Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around ½" hoop in slot.
- d. Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

9. Finishing and Inspection

AD-06

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.



Work Order: 2014-20Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Hoops

1 of 1

Date Opened: 06 MAR 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1			76421-01	Hoop - standard	4130 <del>Steel</del> <sup>stainless steel</sup> 1/2" x 0.035 Sqr. Tube	11101
			76423-07	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop	<del>4130 Steel</del> <sup>SS</sup> 1/2" x 0.035 Sqr. Tube	11101
	. 1		--	1/2" Tube - hoop	4130 <del>Steel</del> <sup>SS</sup> 1/2" x 0.035 Sqr. Tube	11101
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	128 <sup>SS</sup> 12018
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 2		76423-06	Stud	304 <del>4018 Mild Steel</del> 5/8" Dia. <sup>SS</sup>	12074
Step 7	. 2	84262	84272-01	Bushing	4130 <del>Steel</del> <sup>SS</sup> 5/16" x 0.058 Rnd. Tube	8065
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	10037
	. A/R		--	Welding Rod	ER70S-2	
Step 9				Finishing and Inspection	None	



## **CARGO BASKET BODY FABRICATION - COMMON**

W0 2014-20

AS350 LONG STAINLESS

### **General**

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

*Options* 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

#### **Eurocopter AS350/AS355 – left or right**

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

*Options* 70406, Revision 2 – Front end cutout – 764/776/784/940

#### **Robinson R44 – left or right**

90611, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

*Options* 70406, Revision 2 – Front end cutout – 802/803/811

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

*Options* 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

#### **MD600**

82811, Revision 0 – Standard Basket

**Options – Applicable to all models**

70403, Revision 5 – Auxiliary Latch

**CARGO BASKET BODY FABRICATION - COMMON**

**Complete**  
(initial or SCA #)

Work Order: 2014-20

Date Open: 06 MAR 2014

**1. Rim Assembly – Basket Body**

ADL

- a. Cut and fit  $\frac{3}{4}$ " x 0.035 material to fit rim jig.
  - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

**2. Weld Rim Assembly.**

AD-05

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

**3. Inspection**

ADL

- a. Rim for complete welds

**4. Frame assembly – body**

ADL

- a. General
  - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
  - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
  - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
  - i. Ensure correct order and orientation of hoops. Refer to drawing.
    1. Attachment lugs are on inboard side.
    2. Handle bracket bushings are on outboard side, second hoop from both ends.  
May be on attachment hoops.
  - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
  - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
  - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
  - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut  $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut  $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
  - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut  $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut  $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
  - i. Extra large baskets
    - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim
  - ii. All other baskets
    - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
    - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
    - 3. forward and aft hoops align to INSIDE of rim, except R44

## 5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding. AD-05
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

## 6. Inspection

- a. Frame assembly for complete welds. AD-06

## 7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list. AD-07
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
  - i. For extra wide baskets only –
    - 1. Set  $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
    - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
    - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
  - ii. Using markings on table, align sheet to indicated edge.
  - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
  - iv. Bend mesh by hand tightly over tube along length of tube.
  - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
  - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.



- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
  - i. General
    1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
    2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
    3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
    4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
  - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
  - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
  - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - v. Clamp mesh to spine in at least 1 place per section.
  - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
  - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require  $\frac{1}{2}$  to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
  - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh  $\frac{1}{8}$ "- $\frac{3}{16}$ " down at 45 degrees
  - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
  - i. Remove surface rust with scotch-brite.
  - ii. Ensure mesh is cut at intersections where possible.
  - iii. Bend top edge of mesh  $\frac{1}{4}$ " down at 60 degrees.
  - iv. Fit mesh to front end of basket.



## CARGO BASKET BODY FABRICATION - COMMON

Complete  
(initial or SCA #)

AD-05

### 8. Weld mesh to frame assembly per drawing.

- a. Ensure lug locating jig is in place prior to welding.
- b. General welding requirements for all baskets, MIG welding:
  - i. Every intersection at top edges.
  - ii. Every intersection at ends.
  - iii. First 5 intersections down on hoops, then every second intersection.
  - iv. Every intersection along spine.
  - v. Extra large baskets – every intersection along corner.
  - vi. Every intersection around ends
  - vii. Every intersection along struts (if applicable)
- c. Bend and trim cells bent in to fit mesh as required and weld in position.
- d. Grind high spots off body mesh welds on ends before welding end mesh.
- e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
- f. Record welding rod PO on attached material list.

### 9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
  - i. Record welding rod PO on attached material list.
  - ii. Record lid prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
  - i. Cut inboard rim on aft end. Grind flush with hoops.
  - ii. TIG weld caps on open tubes.
  - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
  - i. Record welding rod PO on attached material list.
  - ii. Record placard bracket WO on attached material list.

AD-05

### 10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AD-06

### 11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
  - i. Hoops for height.
  - ii. Rim for width and length and alignment.
  - iii. Lid prop lugs in correct ends.
  - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

AD-01

**CARGO BASKET BODY FABRICATION - COMMON**

**Complete**  
(initial or SCA #)

e. Tag complete basket body assembly in preparation for powder coating.

**12. Powder Coating**

a. Parts are to be powder coated ~~white~~ <sup>dk</sup> in accordance with commercial practices.

b. Record powder coating PO.

c. Inspect powder coating on receiving.

d. Tag basket body assembly and place into stock in preparation for assembly.

OK AS

Work Order: 2014-20

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Body Fabrication

4 of 2

Date Opened: 06 MAR 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			<b>78411-01</b>	<b>Basket Assembly</b>		
<b>Step 1</b>				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (93.25")	4130 <del>Steel</del> <sup>9/5 mm</sup> 3/4" x 0.035 Sqr. Tube	11101
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 <del>Steel</del> <sup>9/5 mm</sup> 3/4" x 0.035 Sqr. Tube	11101
<b>Step 2</b>				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	<del>ER70S-2 TIG Rod</del> <sup>9/5 mm</sup> ER308L	PO# 14005
<b>Step 3</b>				<i>Inspection - Rim</i>	None	
<b>Step 4</b>				<i>Frame Assembly</i>		
	. 4		76421-01	Hoop - standard	4130 <del>Steel</del> <sup>5/5 mm</sup> 1/2" x 0.035 Sqr. Tube	11101
	. 2		76423-01	Attachment hoop (aft)		
	. 5		--	1/2" Tube - spine	4130 <del>Steel</del> <sup>5/5 mm</sup> 1/2" x 0.035 Sqr. Tube	11101
<b>Step 4.g.</b>		70406	70406-01	Option: Front End Cutout		
			70406-03	1/2" Tube	4130 <del>Steel</del> <sup>5/5 mm</sup> 1/2" x 0.035 Sqr. Tube	<del>Hot</del> me
			70406-04	1/2" Tube	4130 <del>Steel</del> <sup>5/5 mm</sup> 1/2" x 0.035 Sqr. Tube	<del>Hot</del> me
<b>Step 5</b>				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	<del>ER70S-2 TIG Rod</del> <sup>5/5 mm</sup> ER308L	PO# 14005
<b>Step 6</b>				<i>Inspection - Frame Assembly</i>	None	
<b>Step 7</b>				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 48" x 92.25")	<del>3/4-16F Expanded Mild Steel sheet</del> <sup>5/5 mm</sup>	4022 11032
	. 2		--	Mesh (End - 22" x 17")	<del>3/4-16F Expanded Mild Steel sheet</del> <sup>5/5 mm</sup>	4022 11032
<b>Step 8</b>				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	<del>ER70S-6 MIG Wire</del> <sup>5/5 mm</sup> ER308L	PO# 2046

Work Order: 2014-20Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Body Fabrication

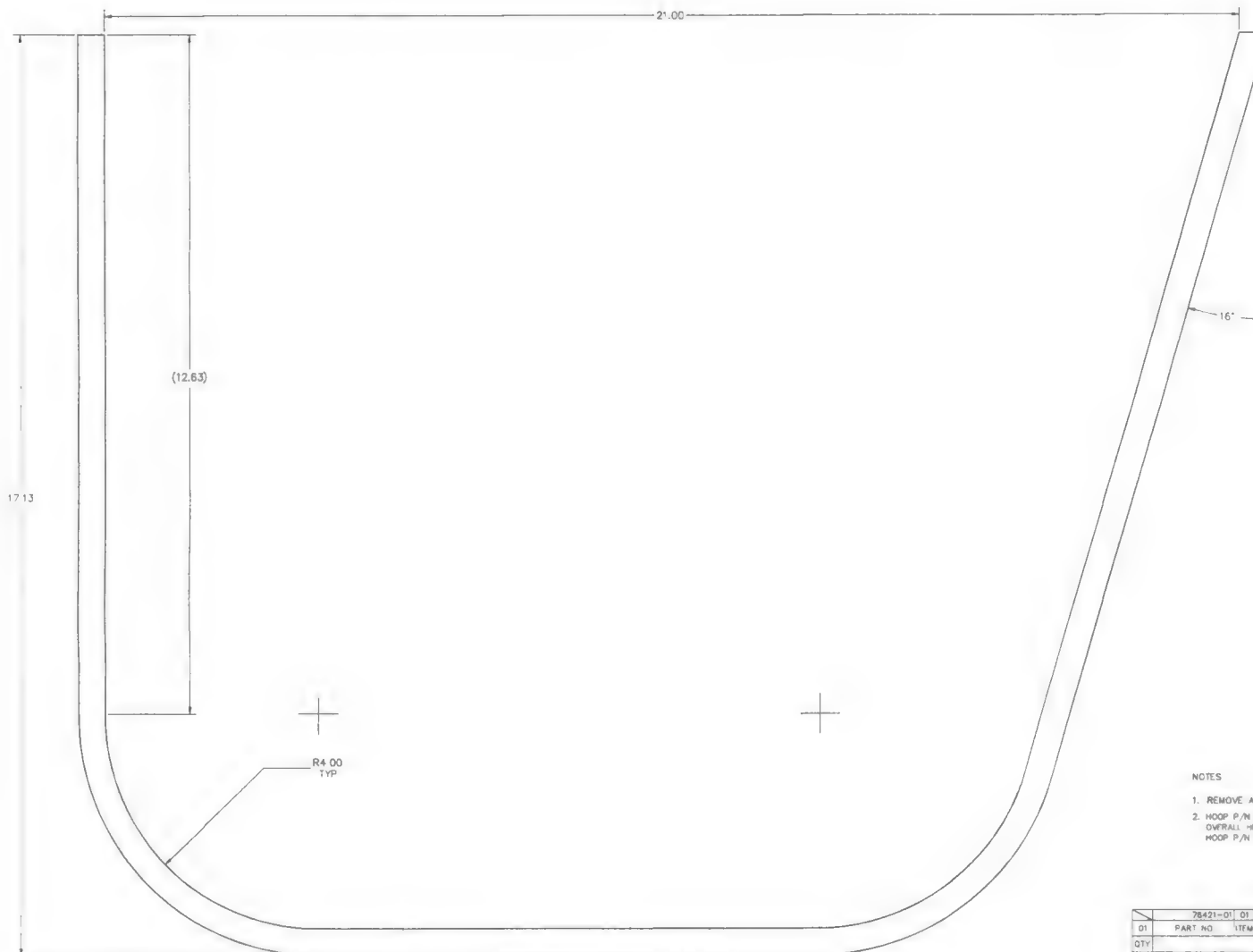
2 of 2

Date Opened: 06 MAR 2014

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
<b>Step 9</b>				<i>Weld Basket Components</i>		
Step 9.a.	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	
	. A/R		--	Welding Rod	ER308L TIG Rod	
Step 9.b.	. 2		--	Cap	1018 <sup>45</sup> Mild Steel, 0.032" Sheet .50 11037	
	. A/R		--	Welding Rod	<del>ER70S-2 TIG Rod</del> ER308L PO#14005	
<b>Step 10</b>				<i>Clean Up</i>	None	
<b>Step 11</b>				<i>Inspection - Final Assembly</i>	None	
<b>Step 12</b>				Powder Coating		



THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER AND USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR ATTENDANCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	24 JAN 08

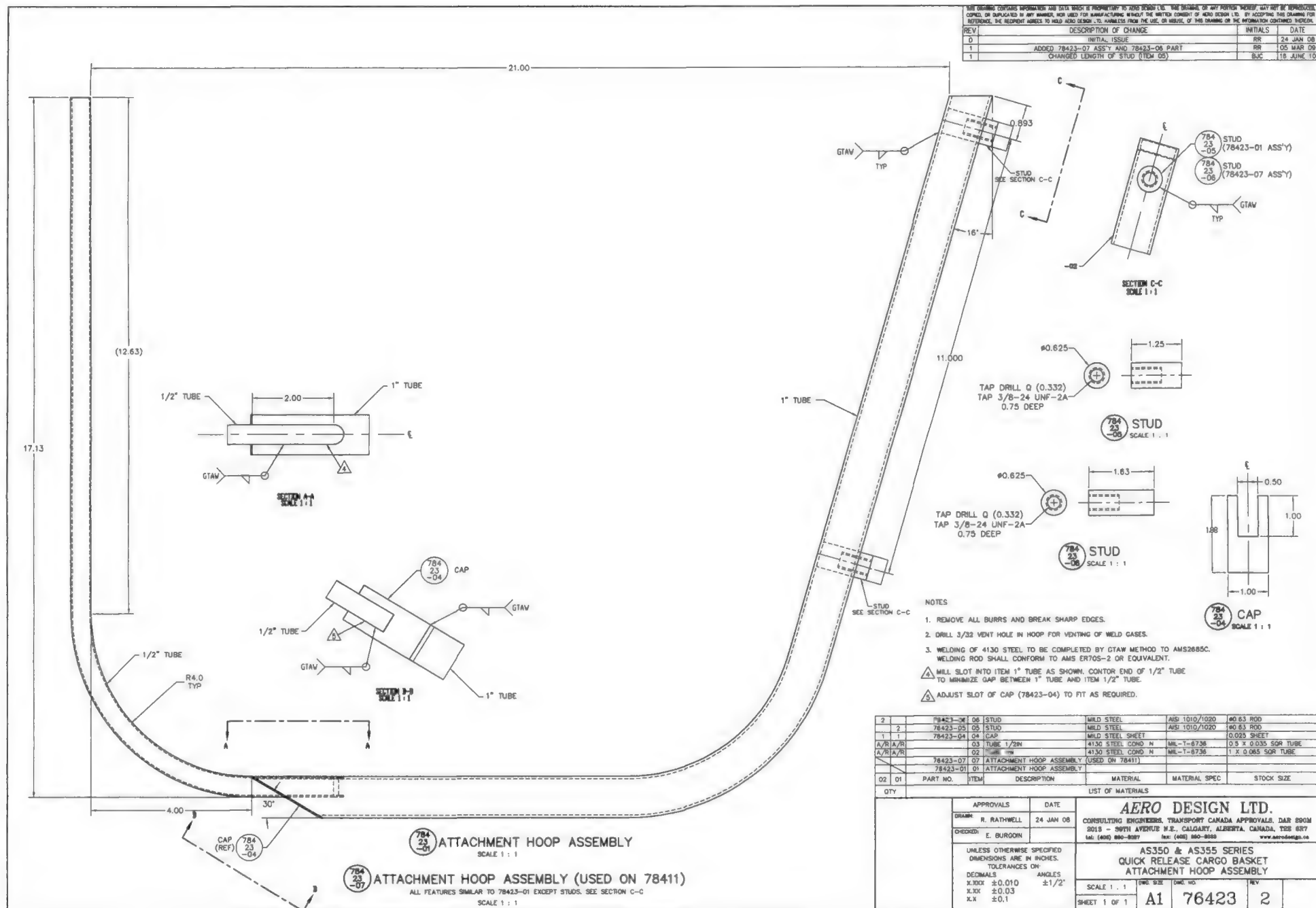


# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. HOOP P/N 50610-01 IS USED AS A DIRECT REPLACEMENT FOR HOOP P/N 76421-01.  
OVERALL HEIGHT IS REDUCED BY 1.38 IN. THERE ARE NO OTHER CHANGES.  
HOOP P/N 50610-01 IS USED ON BASKET S/N 76401-01, 76401-02, 76401-01, 77801-01, 77802-01 ONLY.

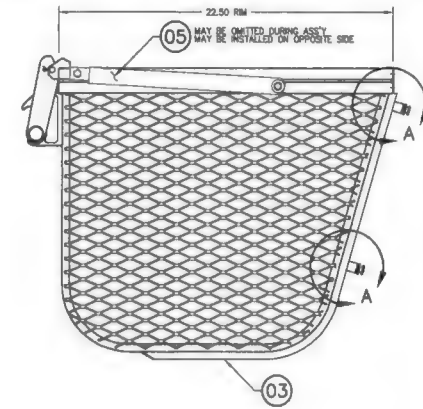
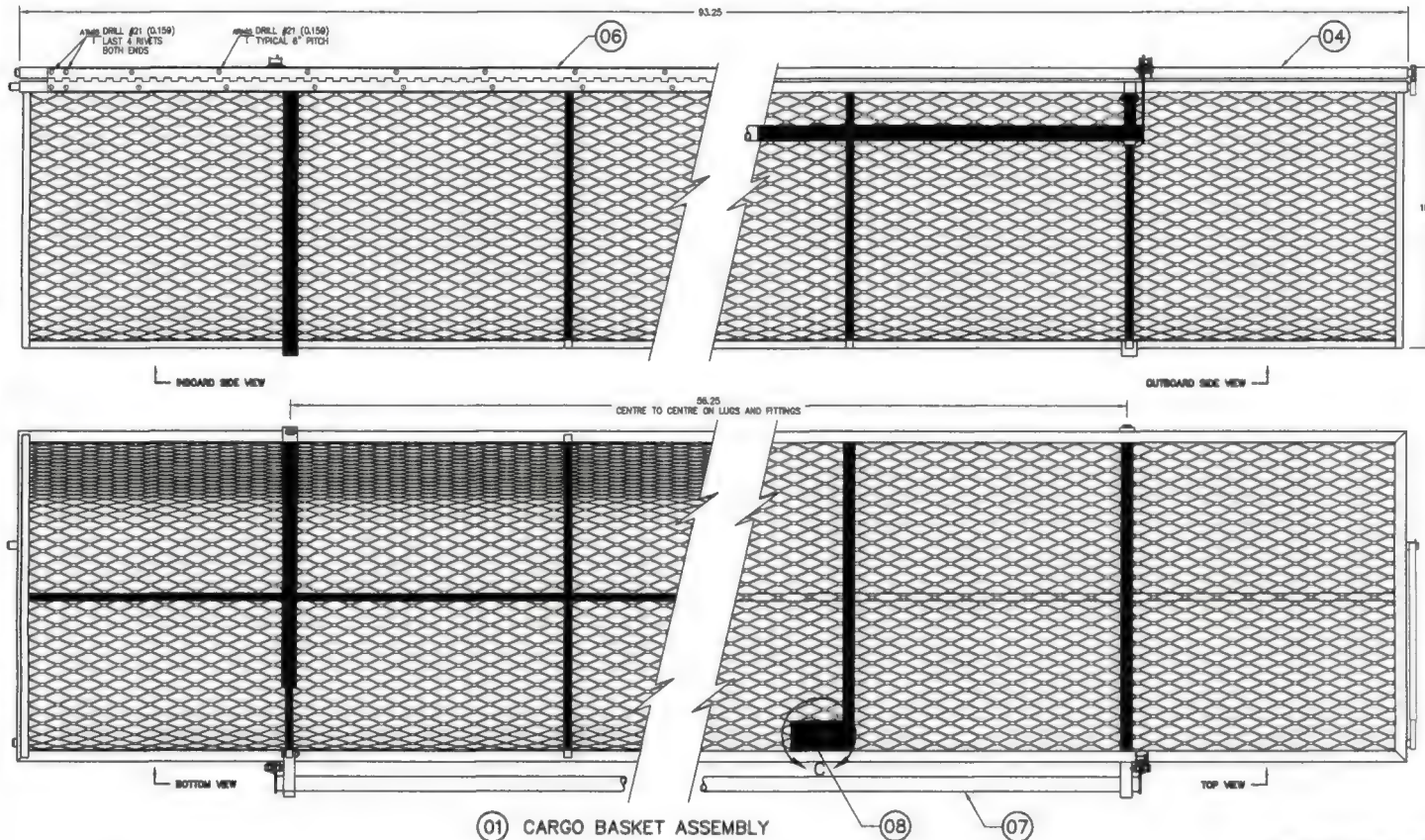
01 HOOP  
SCALE 1 : 1

76421-01 01 HOOP			4130 STEEL COND N	ML-1-6736	0.5 X 0.035 SOR TUBE					
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE				
QTY	LIST OF MATERIALS									
APPROVALS			DATE		<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2901 8013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 566-8997 fax: (403) 566-1888 <a href="http://www.aerodesign.ca">www.aerodesign.ca</a>					
DRAWN R RATH-WEILL			24 JAN 08							
CHECKED E BURDOON										
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:			<b>EUROCOPTER AS350 &amp; AS355 SERIES</b> <b>QUICK RELEASE CARGO BASKET</b> <b>HOOP</b>							
DIMENALS							ANGLES			
X.XXX ±0.010							±1/2°			
X.XX ±0.03										
X.X ±0.1										
SCALE 1 : 1			DWG SIZE	DWG NO	REV					
SHEET 1 OF 1			A1	76421	0					



REV	DESCRIPTION OF CHANGE	INITIALS	DATE
D	INITIAL ISSUE	RR	24 JAN 68
1	ADDED 78423-07 ASSY AND 78423-06 PART	RR	05 MAR 68
1	CHANGED LENGTH OF STUD (ITEM 05)	BJC	18 JUNE 70

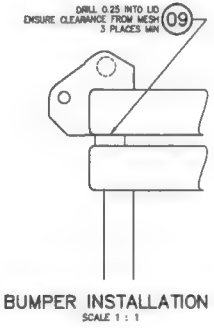
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	CHANGED HANDLE CONFIGURATION, REMOVED ALTERNATE BASKET	BUC	27 JAN 10



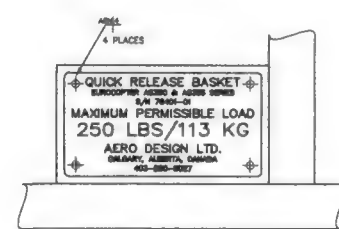
DETAIL A  
SCALE 1 : 2  
TYPICAL FRONT AND REAR

NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

A/R	AN980-616	WASHER				
4	40088-14	FITTING	ANORA			
8	CR3523-3-02	CHERRY RIVET				
A/R	CR3213-3-02	CHERRY RIVET				
4	CR3213-4-02	CHERRY RIVET				
3	49205-14	08 BUMPER	ARGUS INDUSTRIES			
1	78427-01	08 PLACARD				
1	84235-01	07 HANDLE BAR INSTALLATION				
A/R	MS20001P4	06 PLANO HINGE			82 LONG	
1	36280-01	05 BRACE ASSEMBLY				
1	78412-01	04 LID ASSEMBLY				
1	78411-01	03 BASKET BODY ASSEMBLY				
		02				
	78410-01	01 CARGO BASKET ASSEMBLY				
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY				LIST OF MATERIALS		



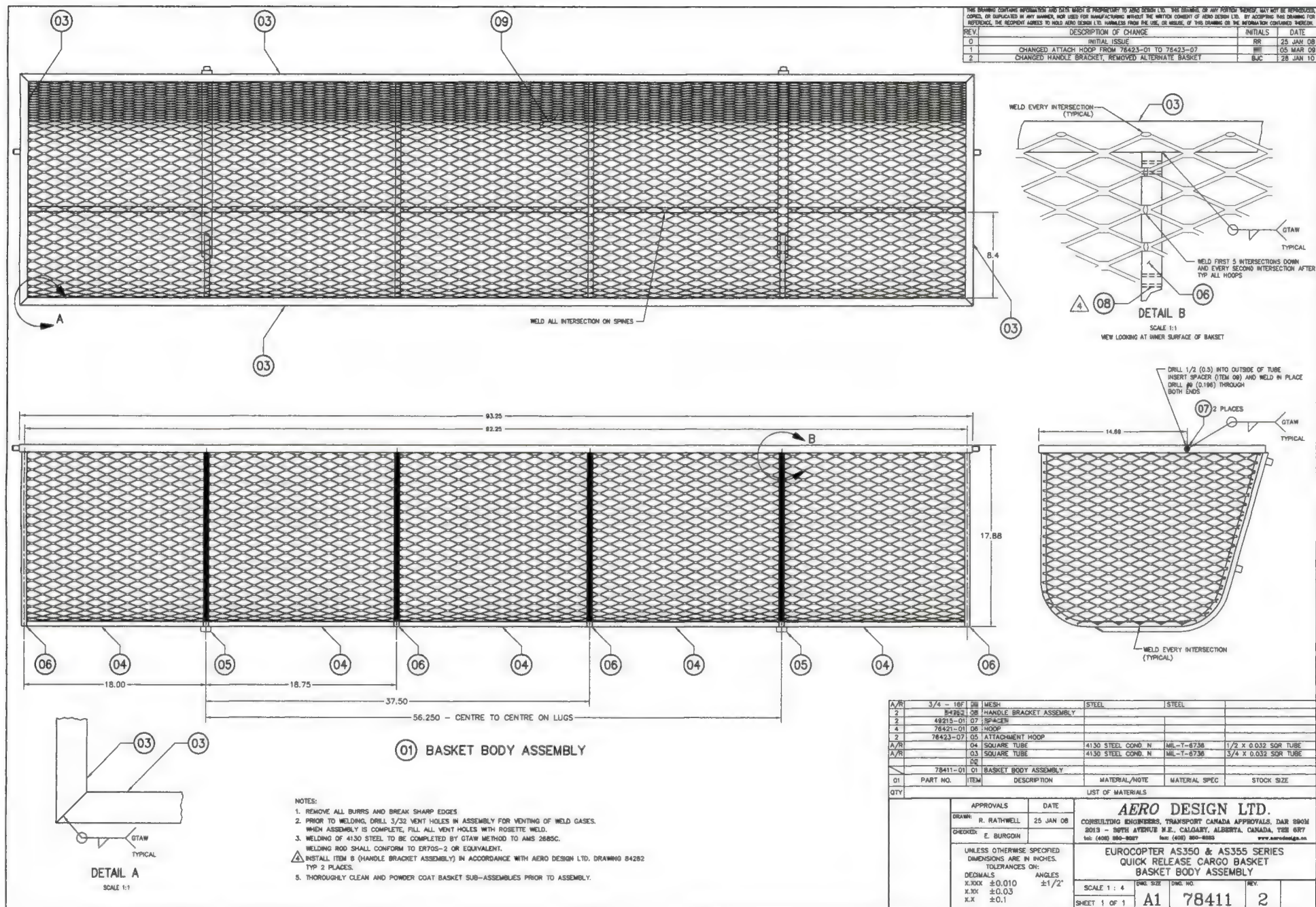
BUMPER INSTALLATION  
SCALE 1 : 1



DETAIL C  
SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

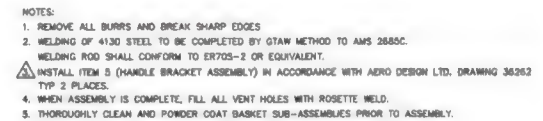
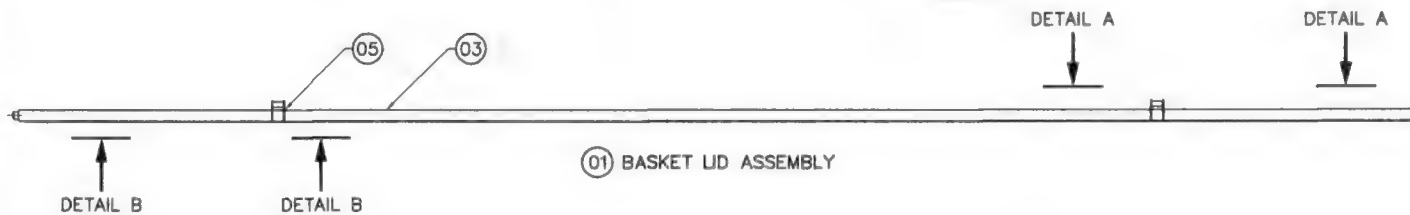
BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF. HAS 523	N=MPD. HEAD NEAR SIDE	DRAWN: R. RATHWELL	19 FEB 08
D=COUNTERSINK	F=MPD. HEAD FAR SIDE	CHECKED: E. BURGOON	
D=DIMPLE			
DIGIT=# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH		
BASIC CODES:		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.	
BJ=MS20470AD		TOLERANCES ON:	
BB=MS20426AD		DECIMALS	X.XXX ±0.010
ARM=CR3213		ANGLES	X.XX ±0.03
ATM=CR3523			X.X ±0.1
	INSTALL NEW RIVET		
	REMOVE/REPLACE RIVET		
	EXISTING RIVET		
LIST OF MATERIALS			
AERO DESIGN LTD.			
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 19008			
2013 - 56TH AVENUE N.E. CALGARY, ALBERTA, CANADA, T2B 6B7			
Tel: (403) 880-8087 Fax: (403) 880-8088 www.aerodesign.ca			
EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE SKI BASKET BASKET ASSEMBLY			
SCALE 1 : 4	DRG. SIZE	DRG. NO.	REV
SHEET 1 OF 1	A1	78410	1







Technical drawing of a wall section showing a cross-section with a diamond-patterned mesh and vertical reinforcement bars. Dimensions are provided for various sections: 16.13, 18.75, 37.50, 56.25, 63.25, and 92.50. A detail callout (06) points to a reinforcement bar with a label "GTAW TYPICAL".



A/R	3/4-18F	07	MESH				
I	M2004-10	06	PLACARD BRACKET				
I	B4262-01	05	UPPER HANDLE BRACKET ASSY				
I	49276-01	04	SPACER				
A/R	CJ	03	SQUARE TUBE	4130 STEEL COND N.	MIL.-T-8738	3/4 X 0.035 SQR TUB.	
		02					
	78412-01	01	BASKET UD ASSEMBLY				
OI	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE	
QTY				LIST OF MATERIALS			

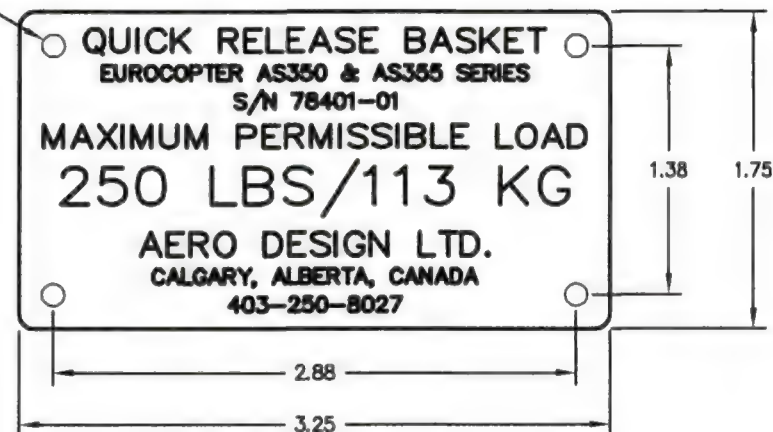
APPROVALS			DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVED, DAR ROOM 3015 - SOUTH AVENUE W.B., CALGARY ALBERTA, CANADA T2B 0V7 Tel: (403) 585-0807 Fax: (403) 585-0865 www.aerodesign.ca
DRAWN:	R. RATHWELL		10 FEB 08	
CHECKED:	E. BURDON			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010     X/Y/Z° X.XX ±0.03 X.X ±0.1				EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY
SCALE 1 : 4				SHEET 1 OF 1
PANEL TITLE SHEET NO. REV.				A1 78412 1

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	INCREASE LOAD TO 250 LBS / 113 KG	BJC	JAN 27/10

# NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:  
"QUICK RELEASE BASKET" - 0.125 HIGH  
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH  
"S/N 78401-XX" - 0.080 HIGH  
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
"250 LBS/113 KG" - 0.200 HIGH  
"AERO DESIGN LTD." - 0.125 HIGH  
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH  
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES



01 PLACARD

78427-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS					

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.

APPROVALS	DATE
DRAWN: R. RATHWELL	18 FEB 08
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	
----------------------------------------------------------------------------------------------------------------------------------------------	--

AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca			
EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET PLACARD			
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	78427	1



WO# 2014-20

Approved Manufacturing Facility 73-04      Form 20.F.06      Rev. Original 27 May 2013

**AERO Design Ltd.**

**ENGINEERING ORDER**

**EO 926.90**

---

**HELICOPTER CARGO BASKETS**

**STAINLESS STEEL CONSTRUCTION**

Prepared by: Jeff Clarke, CET

Approved by: E. Burgoin, DAR 290M

Revision 0, 26 January 2011

---

AERO Design Ltd.  
*Engineering Consultants*  
[www.aerodesign.ca](http://www.aerodesign.ca)

2013 – 39<sup>th</sup> Avenue N.E., Calgary, Alberta T2E 6R7  
Phone: (403) 250-8027  
Fax: (403) 250-8333

Notice: This report contains information and data which is proprietary to AERO DESIGN LTD. This report, or any portion thereof, may not be reproduced, copied, duplicated or used without the written consent of AERO DESIGN LTD.



## TABLE OF CONTENTS

1.0	INTRODUCTION	3
2.0	REFERENCE TEXT	3
3.0	IMPLEMENTATION	3

## 1.0 INTRODUCTION

This Engineering Order is provided to allow for the use of stainless steel materials in place of the 4130 and mild steel materials specified on for AERO Design Ltd. Cargo baskets for various models of helicopter.

The use of stainless steel is to prevent rust stains from occurring on the powder coat in places where the powder coat is chipped or damaged, or where the mesh has pulled away from the basket hoops.

## 2.0 REFERENCE TEXT

AERO Design Ltd. Drawings:

Robinson R44: 90611, 90612

Eurocopter AS350/AS355:78411, 78412, 77611, 77612, 76411

Bell 206B: 80211, 80212, 80311, 80312, 81111, 81112

Bell 206L/407: 76611, 69811, 69812, 60632, 49207, 49208

Bell 205A-1/212: 75111, 75112

## 3.0 IMPLEMENTATION

The following materials may be used as a direct replacement for the materials indicated. The same or heavier sheet or wall thickness as specified on the drawing is required.

Existing - Alloy Steel			Replacement - Stainless Steel			Use
Alloy	Form	Specification	Alloy	Form	Specification	
4130	Tube	MIL-T-6736	304/304L, 316/316L	Tube	ASTM A554	Rims, hoops, etc.
1018	Rod/Bar	AISI 1010/ 1020	304/304L, 316/316L	Rod/Bar	ASTM A479 or A276	Lugs
4130	Sheet	MIL-S-18729	304/304L	Sheet	MIL-S-5059 / AMS 5513 / AMS 5511	Placard bracket, caps
			316/316L	Sheet	MIL-S-5059 / AMS 5524 / AMS 5507	
			321	Sheet	AMS 5510	
1018	Expanded Mesh	commercial	304/304L, 316/316L	Expanded Mesh	commercial	
ER70S-2	welding rod	ASME SF A5.18	ER308L	welding rod	ASME SF A5.9	

This engineering order applies to all AERO Design Ltd. cargo basket configurations including, but not limited to, the drawings listed in section 2.0.